

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019642**Date Inspected:** 21-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LIU HUA JIE**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to the work being performed.

This QA inspector observed the following;

1. INPROCESS:

OBG Trial Assembly

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for side plate located on 12BW+12CW at counter weight side. The weld is designated as SP3053-001-032. The welder is identified as 046709. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1. Further weld detail mention in attached picture

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the T-Rib to T-Rib weld joint for side plate located on 12BW+12CW at counter weight side. The weld is designated as SP3050-001-038. The welder is identified as 046704. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

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ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for side plate located on 12BW+12CW at cross beam side. The weld is designated as SP3038-001-031. The welder is identified as 057333. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the I-Rib to I-Rib weld joint for side plate located on 12BW+12CW at cross beam side. The weld is designated as SP3038-001-034. The welder is identified as 041713. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2213-B-U2-FCM-1.

ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of Fillet welds joining the T-Rib to side plate hold back weld joint located on 12BW+12CW at cross beam side. The weld is designated as SP3039-001-030(12BW) & SP3043-001-010(12CW). The welder is identified as 053486. ZPMC QC Mr. SHI LIE was onsite monitoring the welding variables. The inprocess FCAW appears to be progressing in compliance with WPS-B-T-2132-ESAB.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the deck plate to deck plate transverse splice weld joint located on 12BW+12CW at counter weight side. The weld is designated as CA3012-010. The welder is identified as 046704. ZPMC QC Mr. ZHOU PENG was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2211-B-U2-FCM-1.

ZPMC welding personnel performing Shielded Metal Arc Welding (SMAW) of Complete Joint Penetration (CJP) welds joining the bottom plate to side plate hold back weld joint located on 12BW+12CW at cross beam side. The weld is designated as SEG3005A-004(12BW) & SEG3006A-011(12CW). The welder is identified as 040611. ZPMC QC Mr. ZHU ZHONG HAI was onsite monitoring the welding variables. The inprocess SMAW appears to be progressing in compliance with WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer